

**Work Order ID 159883**

Wednesday, April 19, 2017 12:11:16 PM

**\*159883\***

Page 1

Item ID: D2438

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Clamp

Start Date: 4/22/2017 Start Qty: 60.00

**\*60\***

Cust Item ID:

Required Date: 5/1/2017 Req'd Qty: 60.00

**\*60\***

Customer:

Reference: SCHEDULED/S

DAS

21

9-89

Approvals:

Process Plan:

Date: APR 19 2017

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2438

Rev C

D2727

A1

100

0.00

**\*100\***

PURCHASING

Waterjet

Memo

1.65

FLOW CNC Waterjet

Cut as per dwg D2438

prog rev: Cdwg rev: C

04/17/2017

110

0.00

**\*110\***

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.60

Quality Control

Ensure Material Release Note is attached



04/17/2017

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Item ID: D2438 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Clamp  
Start Date: 4/22/2017 Start Qty: 60.00 **\*60\*** Cust Item ID:  
Required Date: 5/1/2017 Req'd Qty: 60.00 **\*60\*** Customer:  
Reference: SCHEDULED/S

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                                                                          | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp           |
|--------------------------------|---------------------------------------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|--------------------------|
| 120                            | QC8- Inspect parts - second check                                                                 | 0.00                 |         |        |              |               |               |                  |                          |
| <b>*120*</b>                   |                                                                                                   |                      |         |        |              |               |               |                  |                          |
| QC                             | <b>Memo</b>                                                                                       | 1.20                 |         |        |              |               |               |                  |                          |
| Quality Control                | (6.786" center to center)                                                                         |                      |         |        |              |               |               |                  | DAS<br>38<br>APR 24 2017 |
| 130                            |                                                                                                   | 0.14                 |         |        |              |               |               |                  |                          |
| <b>*130*</b>                   | Small Fab                                                                                         |                      |         |        |              |               |               |                  | MAY 01 2017              |
| Small Fab                      | <b>Memo</b>                                                                                       | 0.87                 |         |        |              |               |               |                  |                          |
| Small Fab                      | 1- Use DT9713 clamp holder to hold clamp in place when forming<br>2- Bend as per dwg usind DT9709 |                      |         |        |              |               |               |                  | DAS<br>30<br>9-89        |
| 140                            | QC5- Inspect part completeness to step on W/O                                                     | 0.00                 |         |        |              |               |               |                  |                          |
| <b>*140*</b>                   |                                                                                                   |                      |         |        |              |               |               |                  | MAY 02 2017              |
| QC                             | <b>Memo</b>                                                                                       | 1.20                 |         |        |              |               |               |                  |                          |
| Quality Control                |                                                                                                   |                      |         |        |              |               |               |                  | DAS<br>38<br>9-89        |

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Item ID: D2438 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Clamp  
Start Date: 4/22/2017 Start Qty: 60.00 **\*60\*** Cust Item ID:  
Required Date: 5/1/2017 Req'd Qty: 60.00 **\*60\*** Customer:  
Reference: SCHEDULED/S

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                           | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|----------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 150                            | Identify as per dwg & Stock Location: <u>St542</u> | 0.00                 |         |        |              | <u>60</u>     | <u>800</u>    |                  |                |
| <b>*150*</b>                   |                                                    |                      |         |        |              |               |               |                  |                |
| Packaging                      | Memo                                               | 0.60                 |         |        |              |               |               |                  |                |
| Packaging                      |                                                    |                      |         |        |              |               |               |                  |                |
| 160                            | QC21- Final Inspection - Work Order Release        | 0.00                 |         |        |              |               |               |                  |                |
| <b>*160*</b>                   |                                                    |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                                               | 6.00                 |         |        |              |               |               |                  |                |
| Quality Control                |                                                    |                      |         |        |              |               |               |                  |                |

DAS  
21  
9-89

MAY 04 2017

# Picklist Print

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Page 1

Work Order ID: 159883

**\*159883\***

Parent Item: D2438

**\*D2438\***

Parent Item Name: Clamp

Start Date: 4/22/2017

Required Date: 5/1/2017

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP: E05.06.28Bending removedKJ/JLM

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304S16GA                       |                        | Purchased     |             | No                  |                  | 100             | sf                 | 106.3320       | 0.04        | 2.526318     |               |                |        |

**\*M304S16GA\***

304/316 Sheet .063

**\*\***

02/17/04/22

Location

Loc Qty

Loc Code

MAT010

106.332

m136896

0.3

m137110

0.532

m137175

1.1

m137263

104.4

2.7

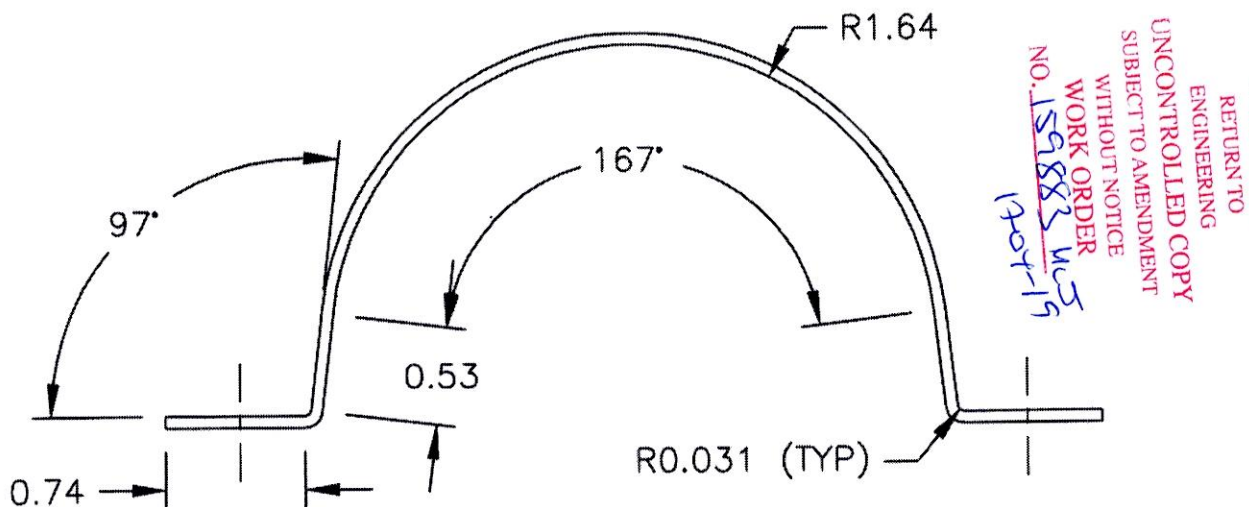




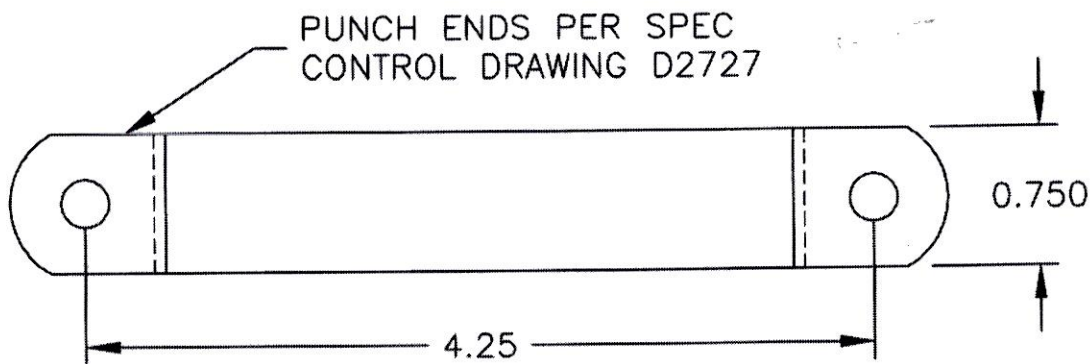


|                      |                       |                                                   |                        |
|----------------------|-----------------------|---------------------------------------------------|------------------------|
| DESIGN<br><i>KE</i>  | DRAWN BY<br><i>KE</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>MS</i> | APPROVED<br><i>MS</i> | DRAWING NO.<br>D2438                              | REV. C<br>SHEET 1 OF 1 |
| DATE<br>98.05.12     |                       | TITLE<br>CLAMP                                    | SCALE<br>1:1           |
| A                    | 96.01.24              | NEW ISSUE                                         |                        |
| B                    | 96.05.13              | CHANGE LENGTH                                     |                        |
| C                    | 98.05.12              | R1.64 WAS R1.438, CHANGE GEOMETRY                 |                        |

RELEASED  
99.06.17 KE



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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 159883 WOS  
1901-15



FLAT LENGTH: 7.586 END-END  
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK  
MINIMUM REQUIREMENT IS ANNEALED CONDITION

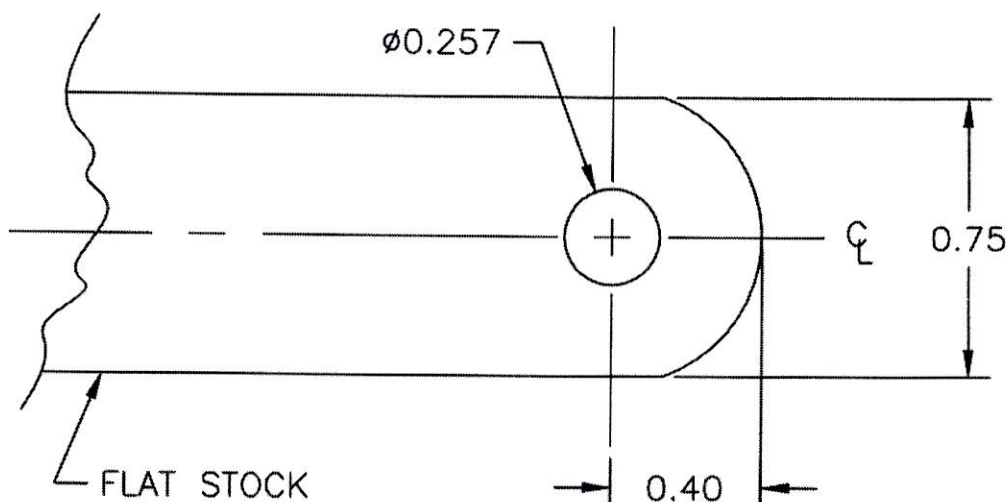
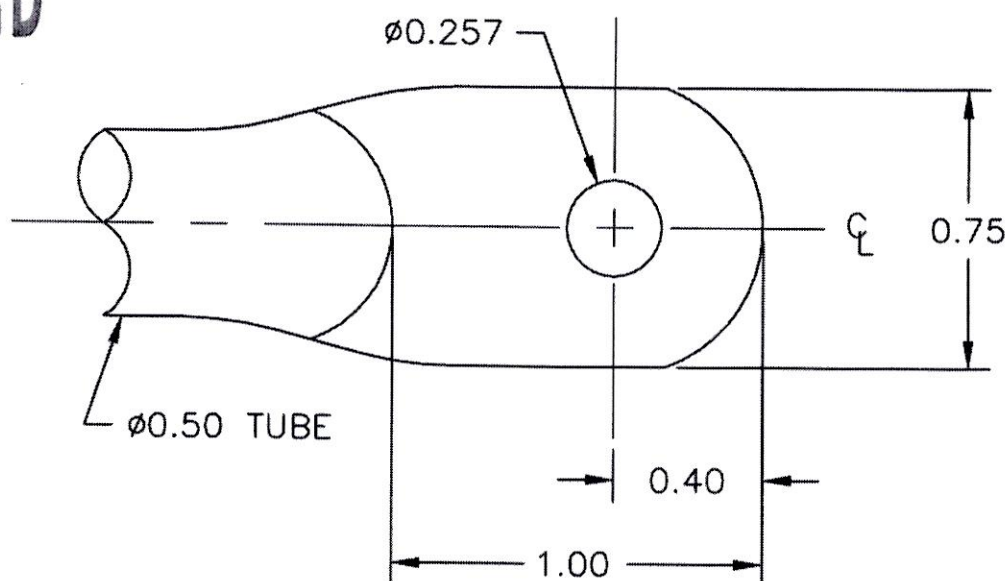
# 00.06.06  
CP 00.06.07



|                      |                       |                                                              |                        |
|----------------------|-----------------------|--------------------------------------------------------------|------------------------|
| DESIGN<br><i>KE</i>  | DRAWN BY<br><i>KE</i> | DART AEROSPACE LTD<br>VICTORIA INTERNATIONAL AIRPORT, CANADA |                        |
| CHECKED<br><i>my</i> | APPROVED<br><i>CA</i> | DRAWING NO.<br>D2727                                         | REV. A<br>SHEET 1 OF 1 |
| DATE<br>97.11.24     |                       | TITLE<br>PUNCH DT8012 SPEC CONTROL                           | SCALE<br>2:1           |
| A                    | 97.11.24              | NEW ISSUE                                                    |                        |
| A1                   | <i>ACP</i> 01.12.20   | ADD TOLERANCE NOTE                                           |                        |

## SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

**RELEASED**  
98/03/06 KE



NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

